

Slip 18/05

Dart Aerospace Ltd.

Date: Thursday, 5/10/2007 2:23:43 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 32270		
Estimate Number	: 12723		
P.O. Number	: N/A	Part Number	: D353613
This Issue	: 5/10/2007 S.O. No. : N/A	Drawing Number	: D3536 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 5/17/2007
Checked & Approved By	: <u>07.05.10</u>	Qty:	4 Um: Each
Comment	: Est Rev: A New Issue 07-02-14 JLM		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.8682 sf(s)/Unit Total : 3.4730 sf(s)  
NEOPRENE SHEET 0.063  
Batch: M103 104

SAD 07/04/12

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3536  
Dwg Rev: A  
Prog Rev: A

SAD 07/05/12

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

36 07.05.12

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

CU 7/5/14 59

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/05/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:23:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32270

Part Number: D353613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

12/03/14

Job Completion



OK 07-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

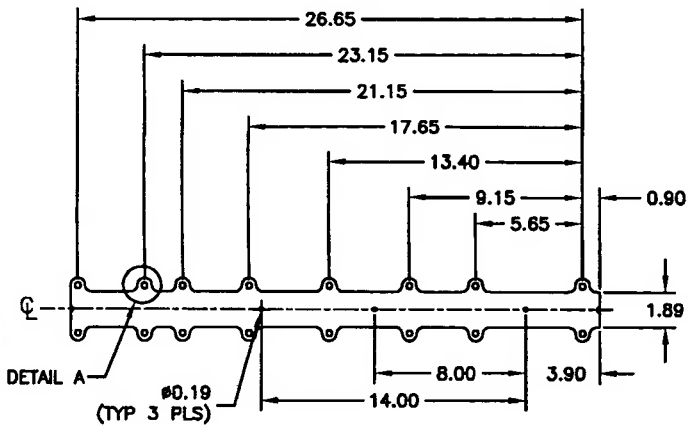
**NOTE:** Date & initial all entries

**DART**

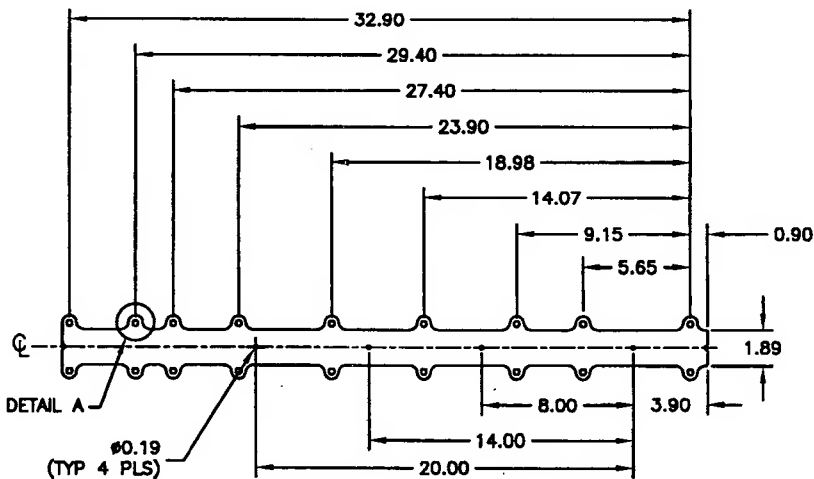
RELEASED

09-02-12-11

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10



**D3536-11 GASKET**



**D3536-13 GASKET**

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32270

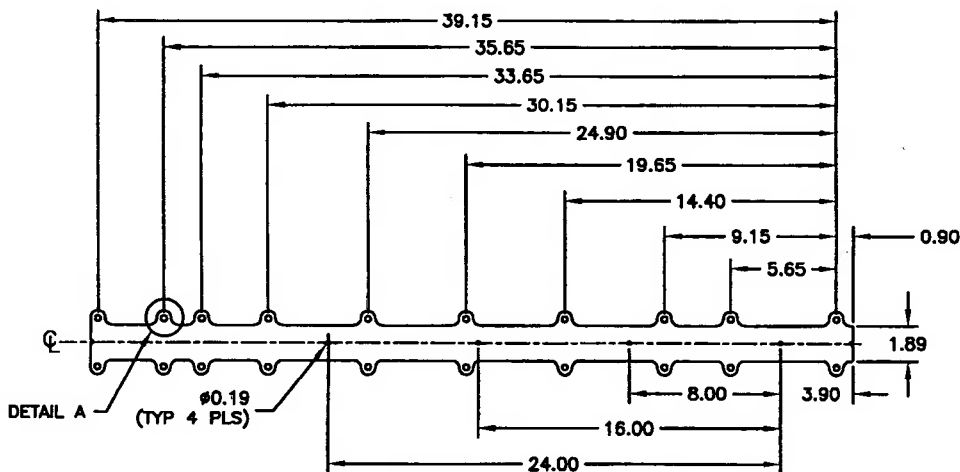
1112

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

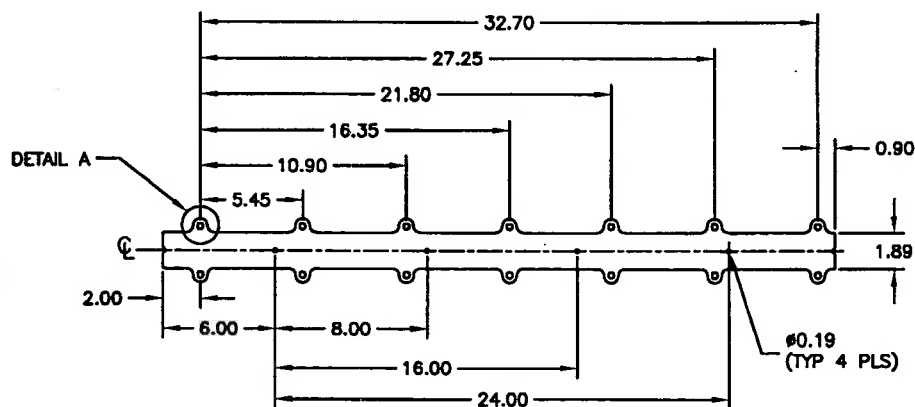
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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 2 OF 6
	SCALE <b>1:10</b>	

RELEASED  
07.02.12



**D3536-15 GASKET**



**D3536-21 GASKET**

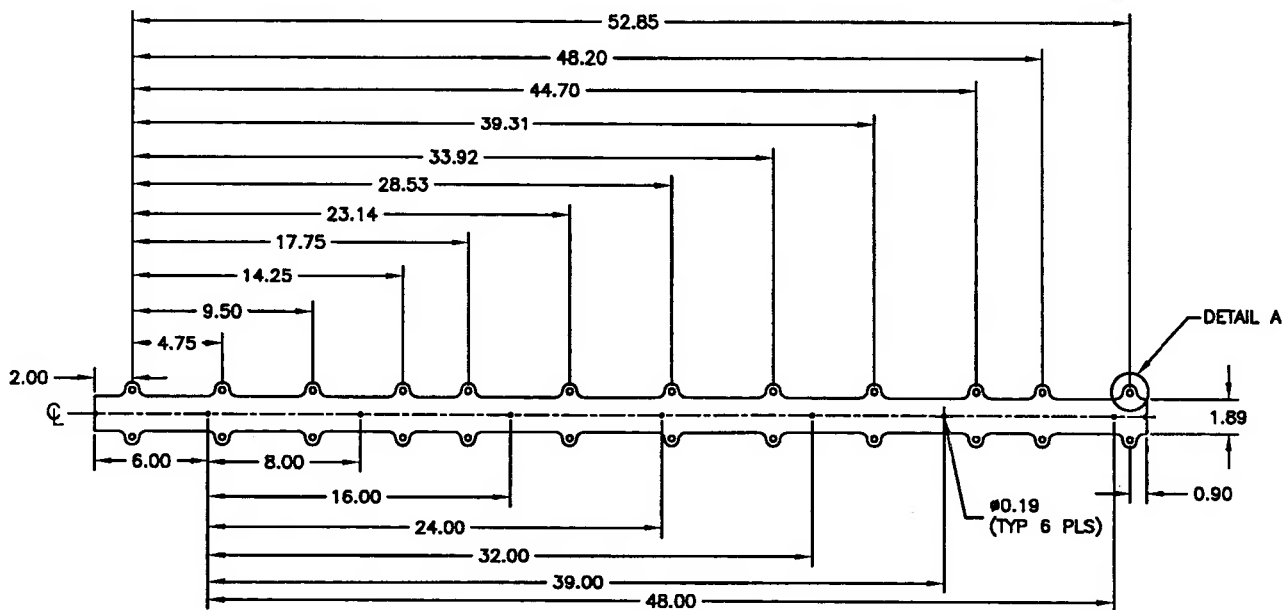
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WITHOUT NOTICE  
WORK ORDER  
NO. 22270

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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- 7) SEE PAGE 6 FOR DETAILS AND SECTION

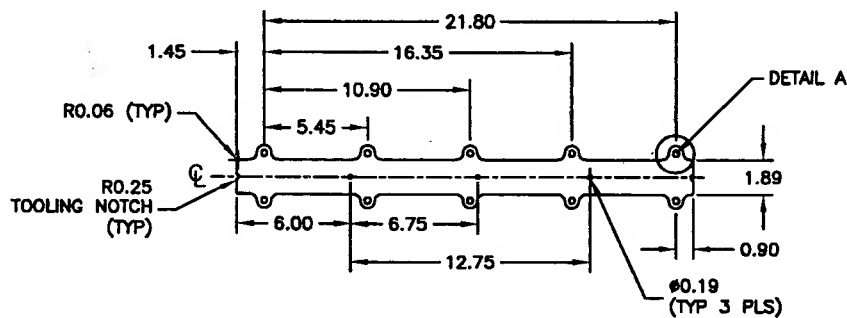
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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 3 OF 6	SCALE <b>1:10</b>

RELEASED  
07.02.12



**D3536-23 GASKET**



**D3536-25 GASKET**

**NOTES**

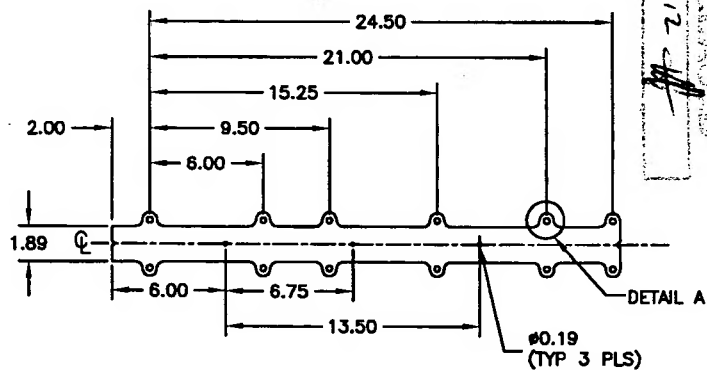
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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WORK ORDER  
NO. 32270

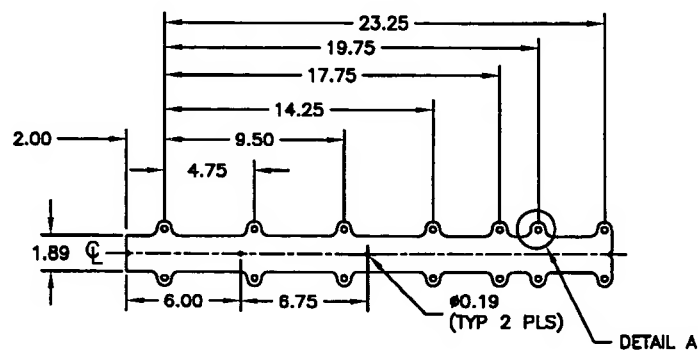
**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 4 OF 6	SCALE <b>1:10</b>

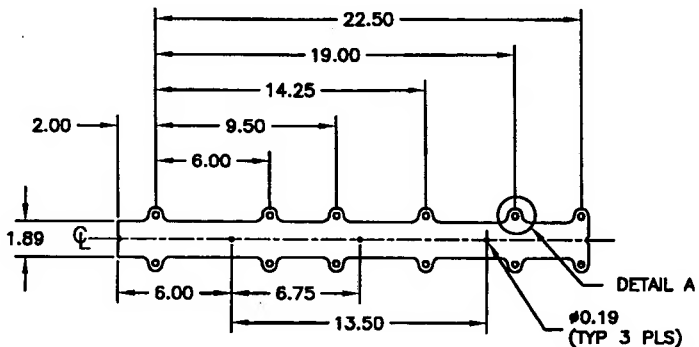
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**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

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WITHOUT NOTICE  
WORK ORDER  
NO. 32270

**NOTES**

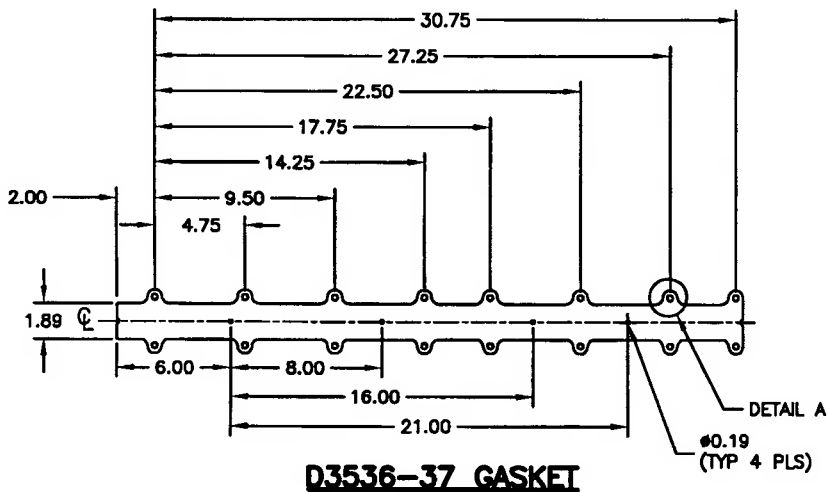
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



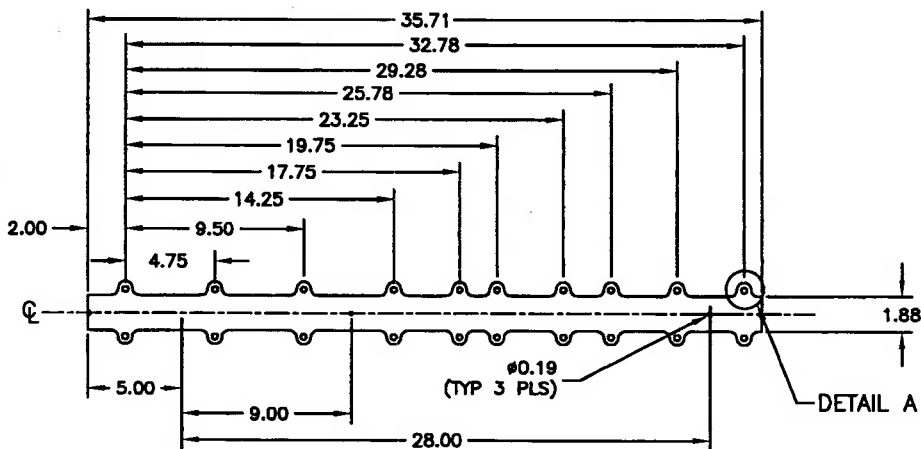
**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 5 OF 6	SCALE <b>1:10</b>

07.02.12  
07.02.12  
07.02.12



**D3536-37 GASKET**



**D3536-39 GASKET**

**NOTES**

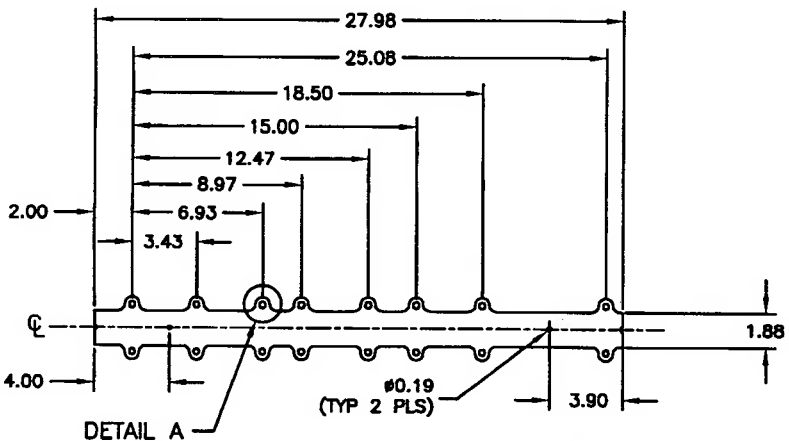
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- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WITHOUT NOTICE  
WORK ORDER  
NO. 32270

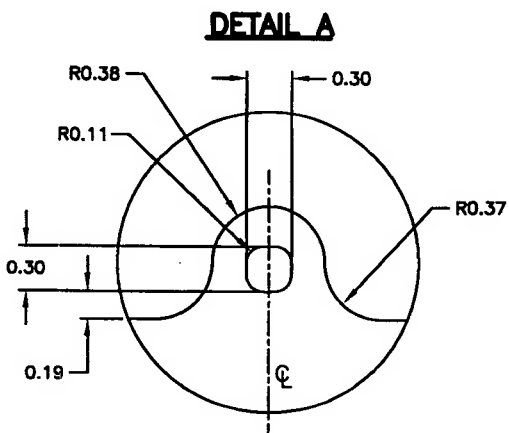


DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10

07.02.12 *[Signature]*



**D3536-41 GASKET**



**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **32270**

DART AEROSPACE LTD		Work Order:	32270
Description: <del>Bear paw</del> GASKET		Part Number:	D353613
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	32.90	+/-0.030	32.90	✓		M-T	
B	29.40	+/-0.030	29.90	✓		M-T	
C	27.40	+/-0.030	27.40	✓		M-T	
D	23.90	+/-0.030	23.90	✓		M-T	
E	18.98	+/-0.030	19.98	✓		M-T	
F	14.07	+/-0.030	14.07	✓		M-T	
G	9.15	+/-0.030	9.14	✓		Vern	
H	5.65	+/-0.030	5.64	✓		Vern	
I	0.90	+/-0.030	0.89	✓		Vern/height gauge	
J	1.89	+/-0.030	1.89	✓		Vern	
K	3.90	+/-0.030	3.90	✓		Vern	
L	8.00	+/-0.030	7.98	✓		Vern	
M	14.00	+/-0.030	13.98	✓		Vern	
N	20.00	+/-0.030	19.99	✓		Vern	
O	Ø0.19	+/-0.030	Ø0.199	✓		Vern	
P	6.30	+/-0.030	6.30	✓		Vern	
Q	0.20	+/-0.030	0.31	✓		Vern	
R	0.063	+/-0.030					
S							
T							
U							
V							
W							
X							
Y							

Measured by: SAD	Audited by: <i>RG</i>	Prototype Approval:	N/A
Date: 07/05/12	Date: 07.05.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	